



WB4480E MMA WELDING ELECTRODE

Classifications	AWS A5.4: E307-26		BS EN ISO 3581-A: E 18 9 Mn Mo R 5 3							
Product Description	Semi-positional, rutile coated mild steel core wire electrode having excellent deslag and bead profile. Recovery is approximately 160%.									
Applications	Used mainly for welding, repairing, and surfacing Austenitic manganese steels. Deposits ~4% Manganese which is crack resistant. Can also be used for surfacing, buttering, and joining mild steels, hardenable and stainless steels to each other. Weld deposit can be fully heat treated without loss of properties.									
All-Weld Metal Composition (Wt. %)		C	Mn	Si	S	P	Mo	Cr	Ni	Cu
min.		0.08	3.30	0.30	-	-	0.5	18.0	9.0	-
max.		0.12	4.75	0.60	0.020	0.025	1.5	21.0	10.7	0.20
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		>620					
	Yield Stress/0.2% Proof Stress		N/mm ²		>388					
	Elongation on 5D		%		47					
	Impact Energy CV @ -20°C		Joules		65					
	As welded									
	Hardness		Hv		~200 AW, ~380 Work hardened					

Electrode Dia (mm)	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
Electrode Length (mm)	-	-	350	350	350	350	-
Current Range (Amps)	min.	-	60	80	100	130	-
	max.	-	90	150	180	220	-
Packaging Information							
Kg Per Packet	-	-	5	5	5	5	-
Approx. Pieces Per Kg	-	-	28	15	10	7	-
Vac Pac Approx. Kg Carton	-	-	-	10.8	10.8	-	-

Storage and Re-baking	<p>Storage It is recommended that the WB range of electrodes are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%. To avoid damage to the coatings no more than 4 cartons should be stacked on top of another.</p> <p>Re-drying (std packaging) Re-dry @ 350°C for 2 hours and then transfer to holding oven and hold @ 100 - 200°C, or 50-100°C in heated quiver.</p>
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Current Conditions AC OCV70 DC +/- and Welding Positions

